

PICKLEBALL PEN KIT

Kit Features

- Easy to Turn with Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-5/16"

Required Accessories

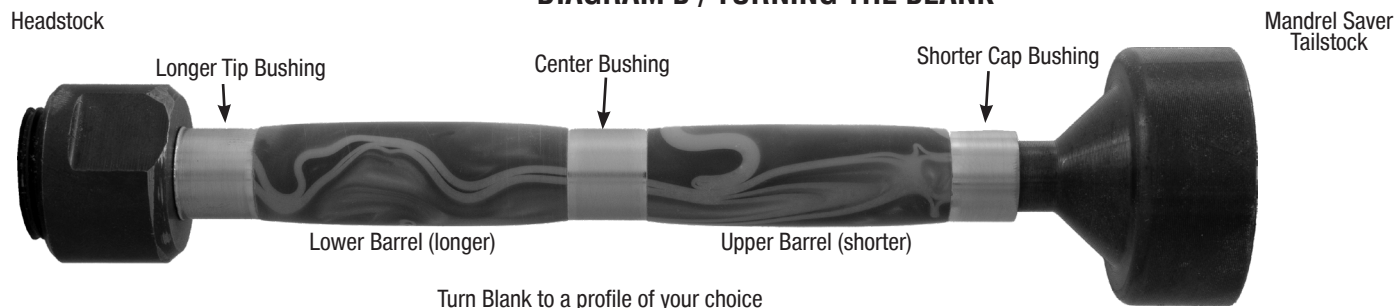
- 7mm Pen Mandrel
- Drill Bit: #PK-38BP for Wood, #PKEXEC-38 for Plastic
- Bushing Set(pc): #PKHOCKBU
- Barrel Trimming: #PKTRIM38 or 3/8" sleeve from #PKTRIMSET with squaring jig on disc sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4" x 3/4" x 3-5/8"L

Preparing the Blank:

- Prior to cutting and gluing, always verify tube length is correct (see parts diagram on back page)
- Cut blanks to the length of the tube, adding 1/16" for squaring off.
- Drill hole lengthwise through the blank.
- Spread glue over tube, insert the tube into the blank while twisting to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use #PK-TRIM38 or a 3/8" barrel trimming sleeve with a pen blank squaring jig on a disc sander. Take the excess material down flush to the ends of the tubes. Do not trim past the end of the tube since this may interfere with assembly and the operation of the mechanism. Use a barrel trimmer to clean the inside of the tube.



DIAGRAM B / TURNING THE BLANK



Turning the Blank:

- **IMPORTANT NOTE:** Tubes are very similar in length. Make sure you put Lower Barrel (longer) on the Tip side and Upper Barrel (shorter) on Cap side.
- Mount the bushings and blanks according to diagram B.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide and lock tailstock directly against bushings and tighten quill until blank and bushings are secure.
- To use Knurled Nut Setup (right), add spacer bushings until past the threads on the end of the Mandrel Shaft.
- Thread on the Knurled Nut and hand tighten to hold all components in place.
- Slide the Tailstock up snugly against the Mandrel shaft, inserting the live center point into the Mandrel dimple.
- Lock Tailstock and hand tighten the quill adjustment with wheel to steady the mandrel. Do not over-tighten, it could damage mandrel shaft.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel straight or to a profile of your choice.
- Sand the blank down to be flush with the bushings, gradually increasing sandpaper grits.
- Finish the barrel using your choice of polish. Allow sufficient time for the polish to cure—refer to polish manufacturer's instructions.

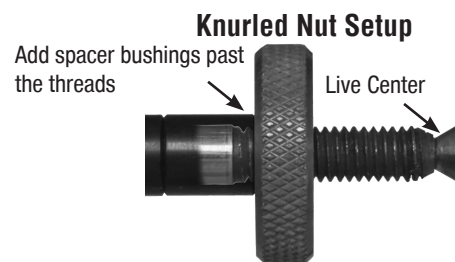


Diagram C / Bushing #PKHOCKBU

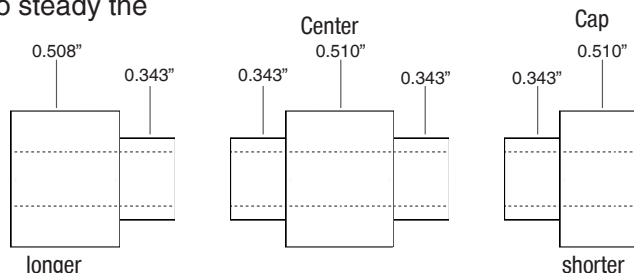
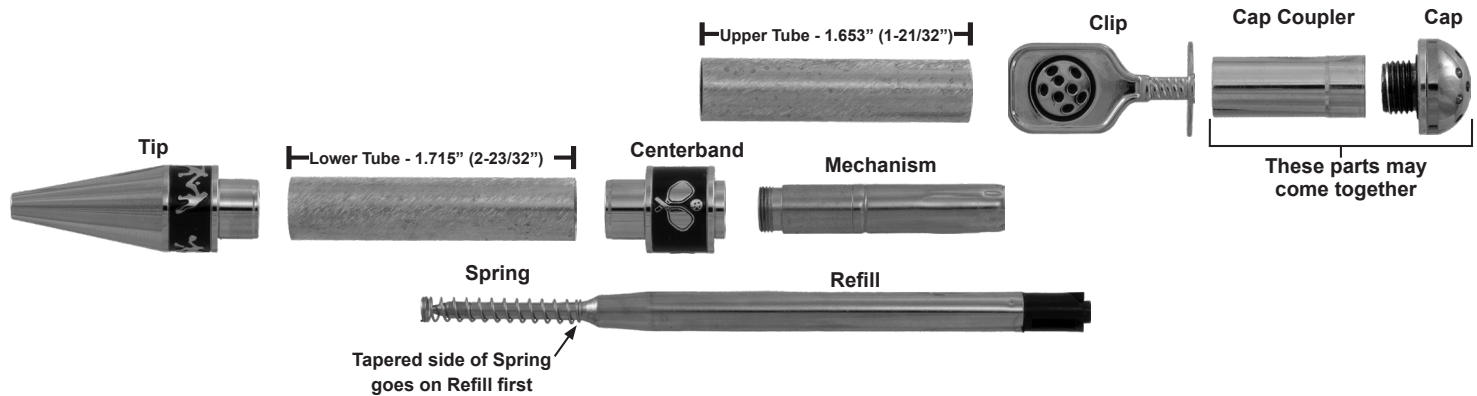


Diagram D / Parts Layout

**Assembly:**

- Make sure to press parts in correct Barrel. Remember Lower Barrel is slightly longer than Upper Barrel
- Press Tip into smaller diameter end of Lower Barrel.
- Press, Centerband into remaining end of Lower Barrel
- Slide Spring, tapered end first onto the shaft of the Refill
- Insert Refill into the opening in Centerband
- Thread Mechanism onto Centerband, over back of Refill
- If Cap and Coupler are together, separate them to avoid pressing on decorative Cap and potentially damaging it
- Press the Coupler into the cap side of the Upper Barrel until it is fully inserted.
- Slide Clip onto Cap and thread Cap into Cap Coupler
- Push two halves of the pen together. Do not use a press for this; Mechanism should slide into place by hand
- Twist the barrels back and forth to extend and retract the refill
- To change the Refill, unthread the Upper Barrel from the Centerband. Remember to change Spring to new Refill.

